

Date: Tuesday, 22/07/2008 11:27:14 AM
 User: Julie Lecocq

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : TUBE |
| Job Number | : 40714 | | |
| Estimate Number | : 13491 | | |
| P.O. Number | : | Part Number | : D37703 |
| This Issue | : 22/07/2008 S.O. No. : | Drawing Number | : D3770 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : 1/1 Type : SMALL / MED FAB | Drawing Revision | : B |
| Previous Run | : | Material | : |
| Written By | : | Due Date | : 10/08/2008 Qty: 8 Um: Each |
| Checked & Approved By | : <u>JUL 08.7.22</u> | | |
| Comment | : Est Rev:A 08-07-21 revB as per dwg DD verified by:EC | | |

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T1000W065

6061T6 RD TUBE 1.00 x .065w



Comment: Qty.: 1.9031 f(s)/Unit Total : 15.2250 f(s)

6061T6 TUBE (1.00" x 0.65" wall)

batch: M108819

FF 08-08-06 (8)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3770

2-drill holes thru to finish size as per dwg D3770

3- deburr



FF 08-08-06 (8)

FF 08-08-10 (8)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/11 (8)

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M2/HA

08.08.11

5.0

QC3

INSPECT POWDER/COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/8/11

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 22/07/2008 11:27:14 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 40714

Part Number: D37703

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



(8)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 135

8/8/11

20

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

2008/12

Job Completion



MF 08-08-11

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

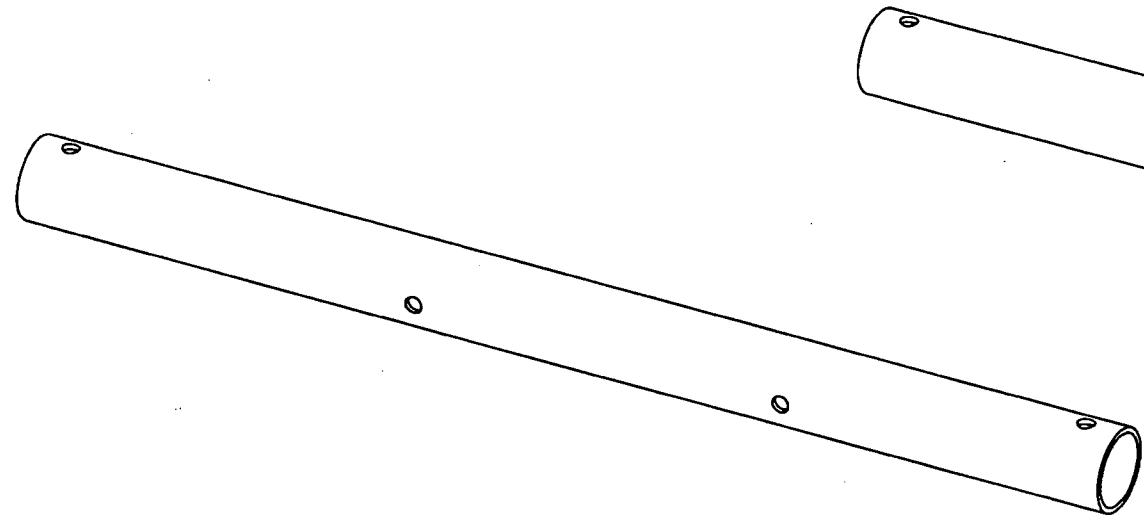
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

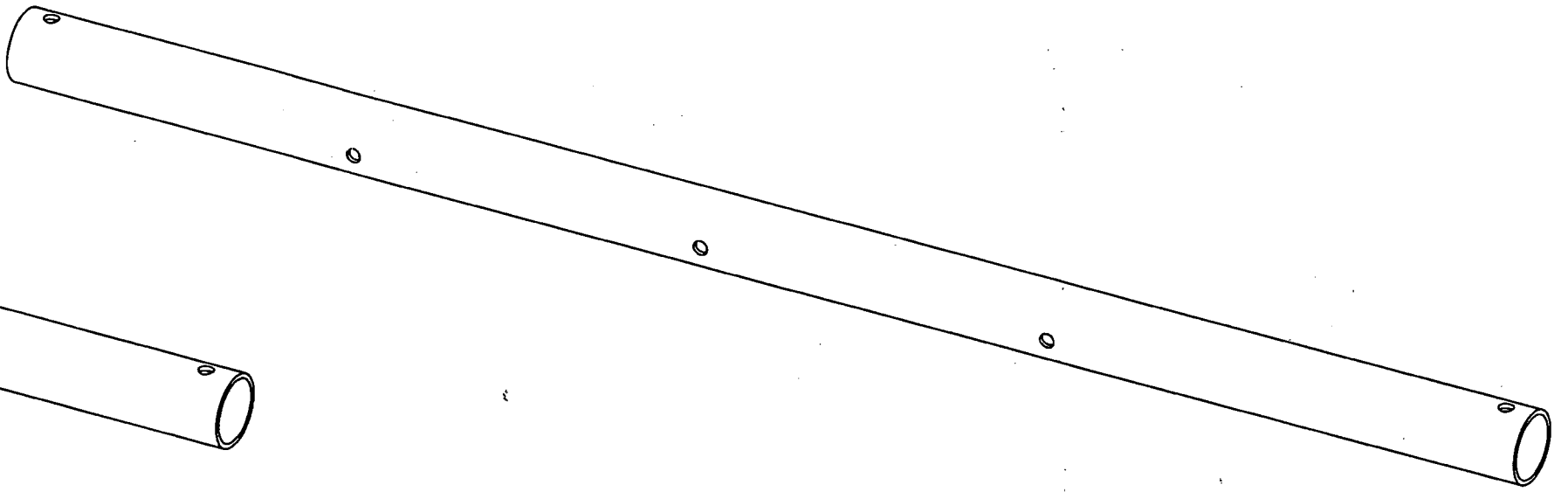
8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D3770-1 TUBE



D3770-3 TUBE

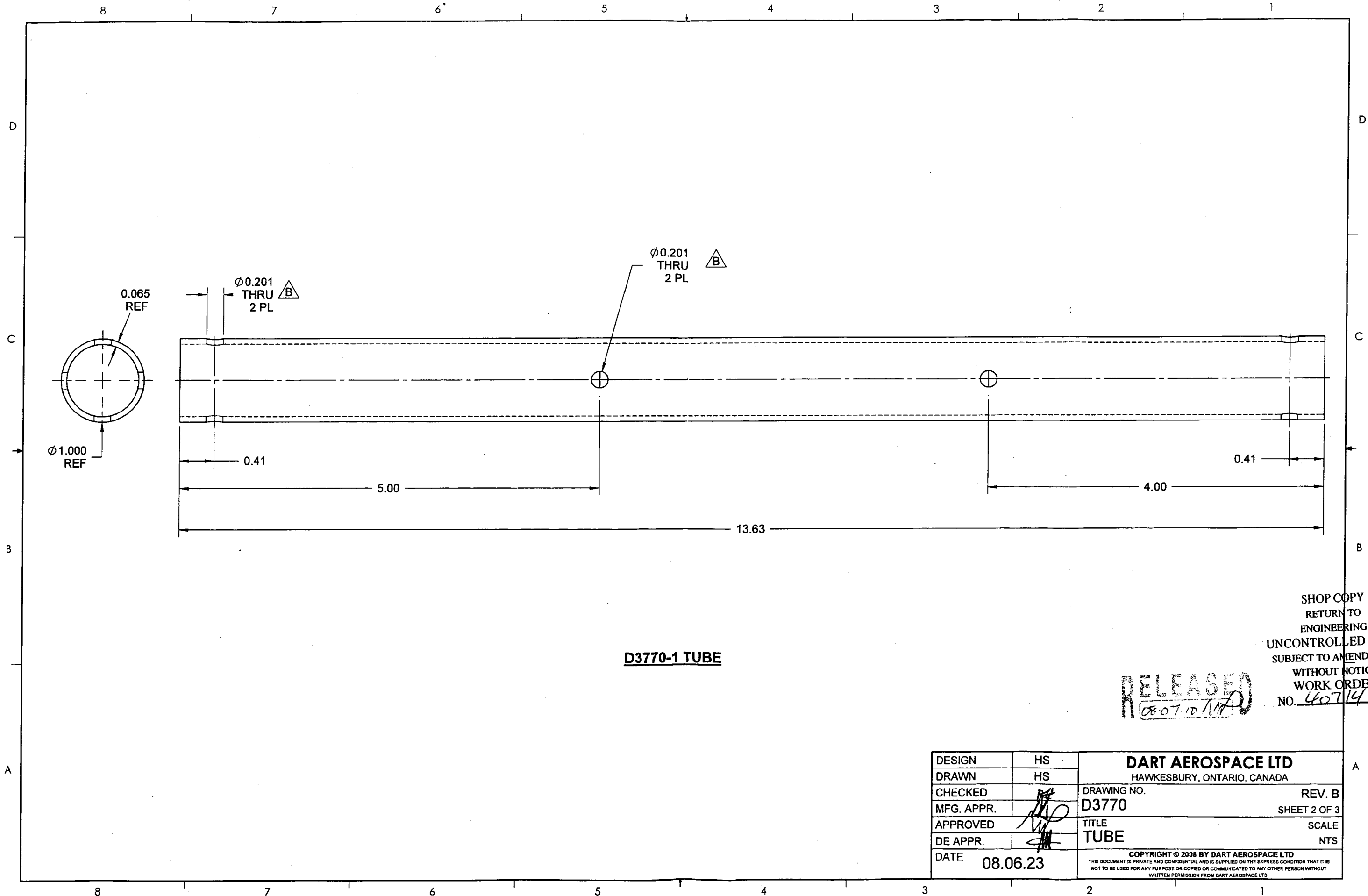
NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D3770-1, 0.25 lbs
D3770-3, 0.40 lbs

RELEASED
08-07-10

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NO. 40714

| | | | |
|------------|----------------------------|--|--------------|
| B | CHANGE HOLES SIZE TO 0.201 | HS | 08.06.23 |
| A | NEW ISSUE | HS | 08.06.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | HS | | |
| CHECKED | PM | DRAWING NO. | REV. B |
| MFG. APPR. | AS | D3770 | SHEET 1 OF 3 |
| APPROVED | JS | TITLE | SCALE |
| DE APPR. | JS | TUBE | NTS |
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8 7 6 5 4 3 2 1

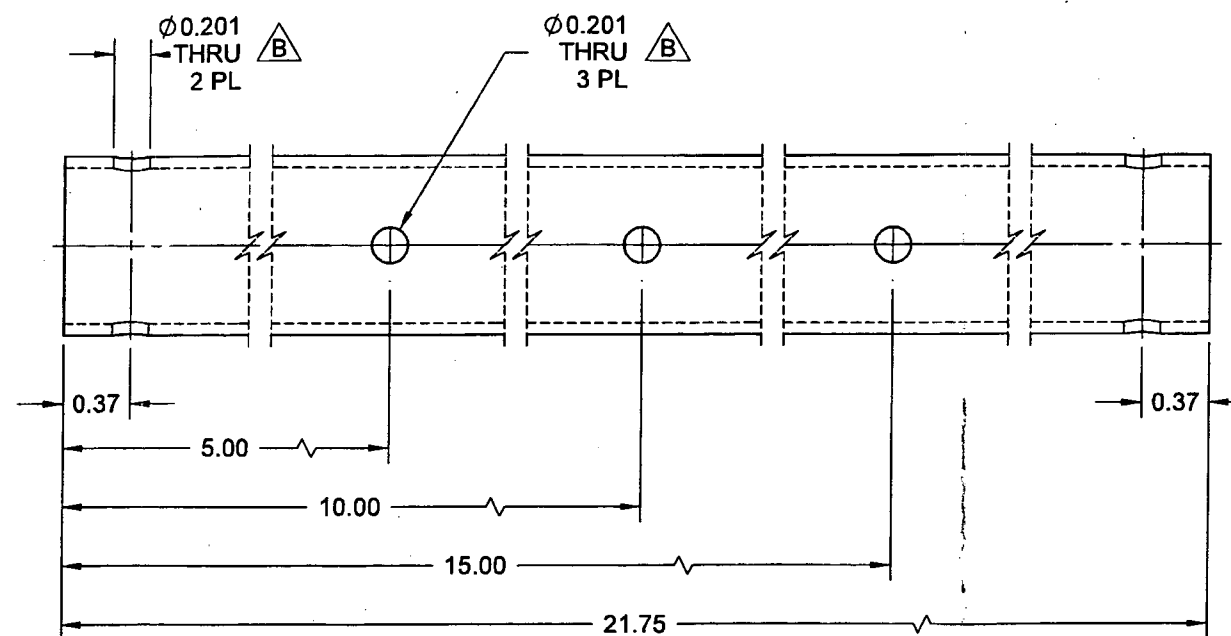
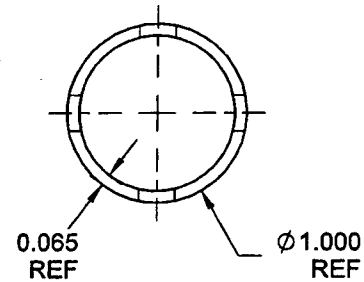


D3770-1 TUBE

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08.07.10

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| DRAWN | HS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3770 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | TUBE | NTS |
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D3770-3 TUBE

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| | | | |
|------------|----------|---|--------------|
| DESIGN | HS | DART AEROSPACE LTD | |
| DRAWN | HS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | PA | DRAWING NO. | REV. B |
| MFG. APPR. | PA | D3770 | SHEET 3 OF 3 |
| APPROVED | PA | TITLE | SCALE |
| DE APPR. | PA | TUBE | NTS |
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